

Date: Tuesday, 4/11/2006 12:42:01 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 26627C			Part Number	: D2221	
Estimate Number	: 10189			Drawing Number	: D2221/D2235	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 4/11/2006		S.O. No. : N/A	Drawing Revision	: F/B1	
Prsht Rev.	: NC			Material	: N/A	
First Issue	: N/A		Type : LARGE FAB ASSY	Due Date	: 4/18/2006	
Previous Run	: 26595A			Qty:	1 Um: Each	
Written By	: See Comment Below					
Checked & Approved By	: See Above User & Date					
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
	4 D3166-1 RIB	B26259	PD	06-04-12
2.0	D22323	Basket Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
	2 D2232-3 Hinge bracket	B25239	PD	06-04-12
3.0	D2325	Support Gusset (350 Bask)		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
	4 D2325 Support Gusset	B25687	PD	06-04-12
4.0	D23273	Spacer Bushing		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
	2 D2327-3 Bushing	B25323	PD	06-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :	
5.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2581 Mounting Bracket <u>B2b204</u>	PD 06-04-12
6.0	D34421	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3442-1 Shim <u>B23544</u>	PD 06-04-12
7.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)	
		Pick:	
		Qty Part Number Description Batch	
		36 sf M304EX0.75-16F Expanded Metal <u>M100518</u>	PD 06-04-21
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)	
		Pick:	
		28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing	
		Batch: <u>M100023 (93") M100560 (51")</u>	
		<u>M100282 (192")</u>	PD 06-04-12
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-04-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA  Date: 06/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/04/25 (1)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/29 (1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M100480

Expiry date: 11/2006

SD 06/05/02 (1)

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/05/04 (1)

Job Completion



SD 06/05/04

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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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